



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A93-5400-00
Job Sheet 194276



Part No: RBE350A93-5400-00

Job Qty: 1 pcs

Part Name: Arriel Engine Mount



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/29/19

Job Tracking No:

Due Date: 6/24/19 *6/28/2019*

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A93-5400-00 REV:4C IPP REV A 18.02.20 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
92	Purchasing	1 pcs	6/24/19		0.00	0.00	Purchasing - 1		<i>DP</i> MAY 09 2019
							Purchasing - 2		
							Purchasing - 3		
94	Packaging 2-1 - Receive - B4B	1 pcs	6/24/19		0.00	0.00	Packaging 2 - 1 - B4B		<i>DP</i> MAY 09 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



Container No: S179927



Part: RBE350A93 - 5400 - 00

Job No: 194276

Serial No/Batch: S179927

Revision: 4C

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632 - 5200
Email: sales@dartaero.com
www.dartaero.com

Date: 05/09/19

Plex 4/30/19 8:37 AM Dart.lajeunesse.marie

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
96 QC 6	1 pcs	6/24/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
100 Small Fab - 2 - B4B	1 pcs	6/24/19	0.08 0.33		Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
110 QC 5	1 pcs	6/24/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
130 Packaging 3-1 - Stock - B4B	1 pcs	6/24/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	

MAY 31 2019
DAS 40
9-89

JUN 05 2019
DAS 68
9-89

				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	1 pcs	6/24/19	0.00 0.00	QC 21 - FG - 21	DARA
				QC 21 - FG - 70	246
				QC 21 - SA - 53	21

GA146B

JUN 06 2019

Part Op 92 - (Purchasing) Issue P/O: 48043377 MANUFACTURE RB _____ AS PER DWG Supplier: METEC
 Descriptions: Certificate of conformity is required

- 94 - (Receive & Inspect for Damage & Mat'l Certs)
- 96 - (QC6- All purchased or subcontracted products)
- 100 - (Small Fab) - Assemble. - Apply T/N and T/NAME
- 110 - (QC5- Inspect part completeness to step on W/O)
- 130 - (Identify as per dwg & Stock Location: _____)
- 140 - (QC21- Final Inspection - Work Order Release)

x 1 hms 03 Mar 2019.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE350A93-5400-00P	Arriel Engine Support	1 pcs (1 ea)	92-Purchasing	5179921
RBE350A93-5400-00-17	Emblem, Tool Number	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5050546
RBE350A93-5400-00-19	Emblem, Arriel Engine Support	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5050554

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
92-Purchasing	RBE350A93-5400-00P	1	2	0
100-Small Fab - 2 - B4B	RBE350A93-5400-00-17	1	5	0
	RBE350A93-5400-00-19	1	5	0

Part Specifications

Specifications could not be found.

Plex 4/30/19 8:37 AM Dart.lajeunesse.marie

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CHANGE FROM M8x1.25 x 190.5mm long HOOK BOLT & HARDWARE BECAUSE OF AVAILABILITY.	11/20/08	WP	DW
2	CHANGED PIPE CORNER RADIUS FROM R4.5 TO R2.5 PER DIE AVAILABILITY.	2/13/09	WP	RW
3	CHANGED TO A 3 PIECE DESIGN	2/10/12	JAG	
4	CH'D Ø1/2 X .065 TO Ø5/8 X .095. CHANGED SOURCE FOR -9 FROM STANLY TO GRAINGER -1 CHANGED -15 HOOK BOLT TO -9 HOOK BOLT. ADDED 1.00 DIM FOR BUSHING -3 CH'D Ø.563 TO Ø.625 S.F. FOR -5. CH'D THRU TO ID TO THRU 1 WALL. -25 CH'D THRU TO ID TO THRU 1 WALL	5/4/12	JAG	
4A	ADDED -3 FABRICATION LAYOUT.	10/22/12	RJC	SE
4B	-3 ADDED NOTE Δ & CHANGED REFERENCE DIMENSION CALLOUTS (21.50) FROM 21.50 REF	1/3/13	BIM	SE
4C	CORRECTED T/N WAS RBEA93-5400-00 IS RBE350A93-5400-00. -5 ADDED DWG. -13 ADDED B/O INFO MCMaster CARR # 90866A140.	5/23/14	DJN	RJC

SEE NOTE

T/NO EMBLEM
BLACK 3/4IN
LETTERS

RBE350A93-5400-00
ASSEMBLY

T/NAME EMBLEM
BLACK 3/4IN
LETTERS

ADD BLK/WHT DYMO
LABEL WITH S/N
"MADE IN USA"

SHC
R
E
UNCC
SUB
V
ORDER
N
194276 MLW
190430

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	WELDMENT		USE -3 & -5	2
	1		-3		TUBE FRAME	DOM	Ø1 x .120 WALL x 30-1/2 (ADD EXTRA FOR BENDING & CUT LENGTH)	3
	2		-5		BUSHING	DOM	Ø5/8 x .095 WALL x 1	7
1		B/O	-7		WASHER	PLAIN	Ø3/8 I.D. x Ø13/16 O.D. MCMaster-CARR #91083A031	4
		B/O	-9	2	HOOK BOLT	PLATED	3/8-16 UNC x 7-1/4 LONG GRAINGER #4PB84	1
		B/O	-11	2	WASHER	PLATED	Ø3/8 I.D. x Ø.734 O.D. MCMaster CARR #94744A265	1
		B/O	-13	2	WING NUT	PLATED	3/8-16 UNC MCMaster CARR #90866A140	1
		B/O	-15	2	FEET	BLACK RUBBER	Ø1 x 1-9/16 HEIGHT MCMaster-CARR #2517T75 BLACK	1
		B/O	-17	1	EMBLEM, TOOL No.	PLASTIC	SIGNS NOW 3/4" LETTERS	1
		B/O	-19	1	EMBLEM, ARRIEL ENGINE SUPPORT	PLASTIC	SIGNS NOW 3/4" LETTERS	1
		B/O	-20	1	DYMO LABEL	VINYL		1
			-21	2	WELDMENT			4
1			-23		LEG	DOM	Ø1.00 X .120 WALL X 20-1/4	5
1			-25		INSERT	DOM	Ø3/4 X .095 WALL X 4-1/4	6
		B/O	-27	2	QUICK-RELEASE BUTTON	S.S.	Ø9/16 MCMaster-CARR #92988A670	1

NOTES:

1. INSERT -27 INTO THE INNER TUBE OF -21.
2. REF. EUROCOPTER T/N: 350A93-5400-00.

RED BARN MACHINE

TITLE ARRIEL ENGINE SUPPORT

DWG NO. RBE350A93-5400-00 REV 4C

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT	
TOLERANCES ON:		APPROVED <i>D Weil</i>	
DECIMALS		FINISH	
XXX ± .005		SPEC	
XX ± .01			
X ± .1			
FRACTIONS ± 1/32			
ANGLES ± 5°			
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		EUROCOPTER AS350A	
SCALE 1:8	DATE 11-20-08	SHEET 1 of 7	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043377



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043377

PO Date: 5/3/19

Due Date: 6/28/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	194276	RBE350A93-5400-00P			Arriel Engine Support As Per Dwg RBE350A93-5400-00 Rev. 4C	Firmed	-	6/28/19	1 pcs	0 pcs	1 pcs	\$746.40/pcs	\$746.40
2	194543	RBW109-3101-58-1P			Hammer, Steel, Blade Corrosion and Voids Detection REV 3	Firmed	-	6/28/19	5 pcs	0 pcs	5 pcs	\$150.00/pcs	\$750.00
3	194544	RBW109-3101-58-2P			Hammer, Aluminum, Blade Corrosion and Voids Detection REV 3	Firmed	-	6/28/19	5 pcs	0 pcs	5 pcs	\$150.00/pcs	\$750.00
Grand Total:													\$2,246.40

DAS
40
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB043377



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

A large, stylized handwritten signature in black ink, likely belonging to Patrick Lussier, is written over the right side of the Order Notes section.

Plex 5/3/19 2:12 PM dart.Lussier.Patrick

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 25189
Shipment Date: 08-May-2019
Ship Via: Pick up at METEC
Order Number: 3802
Order Date: 05/06/19

Customer Code: DART
Phone: (613) 632-9577
PO Number: POHB043377
Terms: Net 60 Days

----- Quantity -----								
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Job Number</u>
1	1	1	0	0	EA	RBE350A93-5400-00P Arriel Engine Support	4C	3802-01

DAS
40
9-89

RECEIVED

MAY 09 2019

DART AEROSPACE LTD.

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By
Dart Aerospace Ltd.



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	P.O. Number
1	RBE350A93-5400-00P	Arriel Engine Support	4C	HB043377

MATERIAL: supplied by METEC

DAS
40
9-89

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


George Theoret

Vankleek Hill, May 8, 2019